

# Work Order ID 63704

November 10, 2010 10:55:01 AM

Page 1

Item ID: D212-725-1-237F

Accept

Setup Start

Revision ID:

Stop

Item Name: Angle

Start Date: 11/10/10 Start Qty: 2.00

Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D212-725-1

G

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

2079 . 24

1-Cut as per Dwg

Dwg Rev: G

Prog Rev: G

2-Deburr if necessary

B10-11-11

3

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-11-11

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Item ID: D212-725-1-237F

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Revision ID:

Stop

Item Name: Angle

Start Date: 11/10/10 Start Qty: 2.00

Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

**Work Order ID 63704**

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Item ID: D212-725-1-237F

Accept

Revision ID:

Item Name: Angle

Start Date: 11/10/10 Start Qty: 2.00

Required Date: 11/15/10 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

3 BR 10-11-16

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=) M 10/11/16

3 0

170

Identify as per dwg &amp; Stock Location:

399

0.00



Packaging

Memo

0.00

Packaging

C. 10/11/16 3

# Work Order ID 63704

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Page 4

Item ID: D212-725-1-237F

Accept

Setup Start

Revision ID:

Stop

Item Name: Angle

Start Date: 11/10/10 Start Qty: 2.00

Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/11/10

ms  
10-11-17

# Picklist Print

November 10, 2010 10:55:01 AM

Page 1

Work Order ID: 63704

Parent Item: D212-725-1-237F

Parent Item Name: Angle



Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 10.07.22 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	280.8400	0.2661	0.560211	8		



2024-T3 .040 sheet



1810-11-11

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	71.6	
114415	71.6	
MAT22	209.24	
110305	21.93	
111786	9.66	
112291	28.25	
112331	52	
113162	97.4	

_____
_____
_____
_____
_____
_____
113162

③

D 210-705-1-237 F

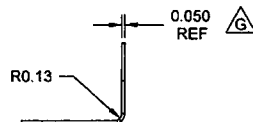
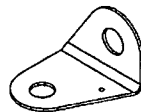
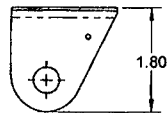
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Measured by:	HB
Date:	10-11-11

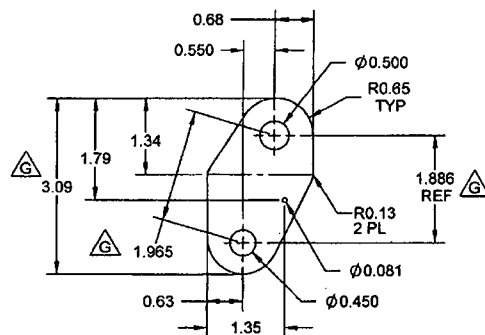
<b>Audited by:</b>	8
<b>Date:</b>	10/11/11

<b>Prototype Approval:</b>	
<b>Date:</b>	

H:\FORMS\Quality Assurance\approved QA\FAI revD

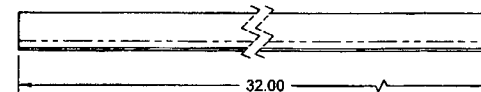


**D212-725-1-227 BRACKET**  
(MAKE FROM D212-725-1-227F FLAT PATTERN)

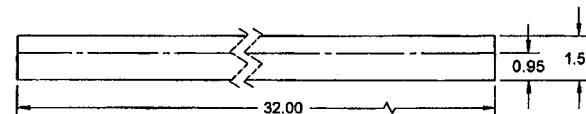
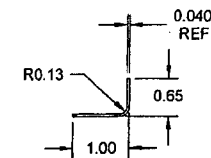


**D212-725-1-227F FLAT PATTERN**

- D212-725-1-227 NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET  
PER MIL-S-5059  
OR AMS 5513 (304)  
OR AMS 5524 (316)  
OR ASTM A240  
OR ASME SA240
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.02 lbs

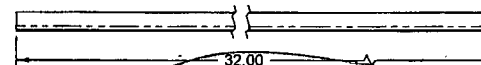


**D212-725-1-235 ANGLE**  
(MAKE FROM D212-725-1-235F FLAT PATTERN)

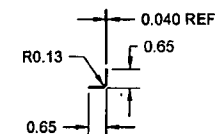


**D212-725-1-235F FLAT PATTERN**

GRAIN  
DIRECTION



**D212-725-1-237 ANGLE**  
(MAKE FROM D212-725-1-237F FLAT PATTERN)



**D212-725-1-237F FLAT PATTERN**

GRAIN  
DIRECTION

- D212-725-1-235/-237 NOTES:**
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK  
REF. DART SPEC. M2024T3S.040
  - 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: N/A

RELEASED

10-0731

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	RF		DRAWING NO.	REV. G
MFG. APPR.	RF		D212-725-1	SHEET 80 OF 84
APPROVED	RF		TITLE	SCALE
DE APPR.	RF		212S DETAIL PARTS	NTS
DATE	10.02.12	COPYRIGHT © 2006 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries